

Work Order ID 111915

Monday, January 27, 2014 10:15:55 AM

111915

Ship Jan 31st

Friday

Page 1

Item ID: D412-786-021

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Hard Point Installation

Stop

NS2

Start Date: 1/27/2014 Start Qty: 5.00

5

Cust Item ID:

Required Date: 1/31/2014 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: WNE Date: 14-1-27 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D412-786-1	B

100		0.00							
-----	--	------	--	--	--	--	--	--	--

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-786-021 chg001

DAS
6
9-89

5

SD 14/2/14

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

DAS
31
9-89

14/4/30 (5)

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

DAS
6
9-89

14/2/14

5

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Page 2

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Item Name: Hard Point Installation

Start Date: 1/27/2014 Start Qty: 5.00

5

Cust Item ID:

Required Date: 1/31/2014 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-786-021

Location: _____

PPP Rev: _____

SHIP

(50)

14.2.6

DAS

9-89

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

14-02-6

MF

14-2-06

Picklist Print

Monday, January 27, 2014 10:15:54 AM

Page 1

Work Order ID: 111915

Parent Item: D412-786-021

Start Date: 1/27/2014

Required Date: 1/31/2014

Parent Item Name: Hard Point Installation

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A 13.11.01 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-786-013 Fwd Hardpoint Installation	DAS 6 9-89	Manufactured	No				Each	0.0000		11/9/16	DAS 33 9-89		DAS 31 9-89
D412-786-025 Tailboom Mount		Manufactured	No				Each	0.0000		11/9/23	DAS 33 9-89		14-01-28 DAS 9-89

Ship per order

Friday

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Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Hard Point Installation

Start Date: 1/27/2014 Start Qty: 5.00 *5*

Cust Item ID:

Required Date: 1/31/2014 Req'd Qty: 5.00 *5*

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: WME Date: 14-1-27 Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D412-786-1	B								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D412-786-021 chg001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

1401-28
see attached
P

Change Record

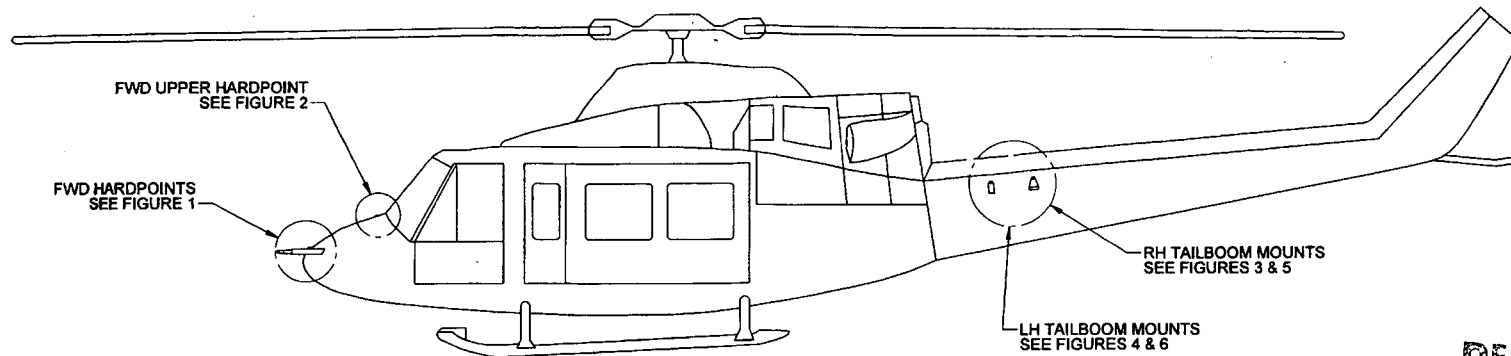
PAGE 1 OF 1

Part Number: D412-786-021

Description: HARDPOINT INSTALLATION

[illegible]

REFERENCE ONLY



D412-786-011 /-021 HARDPOINT KIT

QTY -011	QTY -013	QTY -015	QTY -021	QTY -025	PART NUMBER	DESCRIPTION
X					D412-786-011	HARDPOINT KIT
1	X				D412-786-013	FWD HARDPOINT KIT
1		X			D412-786-015	TAILBOOM MOUNT KIT
			X		D412-786-021	HARDPOINT KIT
				X	D412-786-025	TAILBOOM MOUNT KIT
		1			D3866-041	TAILBOOM MOUNT
		2			D3866-043	TAILBOOM MOUNT
	1				D3870-041	FWD LH HARDPOINT
	1				D3870-042	FWD RH HARDPOINT
	1				D3870-5	FWD UPPER HARDPOINT
	1				D3871-1	DOUBLER
	1				D3871-2	DOUBLER
			1		D4950-041	TAILBOOM MOUNT
					D4950-043	TAILBOOM MOUNT
	10	12			MS2T042L3	NUT
	8	12			MS27039-1-11	SCREW
	1				MS27039-1-42	SCREW
	1				MS27039-1-14	SCREW
	10	24			NAS1149D0322-1	WASHER

INSTALLATION	WEIGHT	LONGITUDINAL		LATERAL	
		ARM	MOMENT	ARM	MOMENT
D412-786-011 HARDPOINT KIT	0.58 LBS 0.26 KG	164.67 IN 4.18 M	95.51 IN-LB 1.09 KG-M	-1.25 IN -0.03 M	-0.73 IN-LB -0.008 KG-M
D412-786-013 FWD HARDPOINT KIT	0.22 LBS 0.10 KG	-13.55 IN -0.34 M	-2.98 IN-LB -0.03 KG-M	2.36 IN 0.06 M	0.52 IN-LB 0.006 KG-M
D412-786-015 TAILBOOM MOUNT KIT	0.36 LBS 0.16 KG	273.58 IN 6.95 M	98.49 IN-LB 1.11 KG-M	-3.47 IN -0.09 M	-1.25 IN-LB -0.01 KG-M
D412-786-021 HARDPOINT KIT	0.64 LBS 0.29 KG	164.67 IN 4.18 M	105.39 IN-LB 1.21 KG-M	-1.25 IN -0.03 M	-0.08 IN-LB -0.01 KG-M
D412-786-025 TAILBOOM MOUNT KIT	0.42 LBS 0.19 KG	273.58 IN 6.95 M	114.90 IN-LB 1.32 KG-M	-3.47 IN -0.09 M	-1.46 IN-LB -0.02 KG-M

- NOTES:
- 1) D412-786-011/-021 HARDPOINT KIT REQUIRED ON 412/412EP AIRCRAFT UTILIZING D412-695-011 BLADE FOLDING KIT WHERE WIRE STRIKE COMPATABILITY IS REQUIRED
 - 2) D412-786-021 HARDPOINT KIT REQUIRED ON AIRCRAFT EQUIPPED WITH BLR TAILBOOM STRAKE KIT.
 - 3) TOUCH UP DRILLED HOLES WITH ALODINE PER THE AIRCRAFT MAINTENANCE MANUAL
 - 4) TORQUE FASTENERS AS FOLLOWS: 10-32: 20-25 IN-LBS
 - 5) PRIME AND PAINT HARDPOINTS TO MATCH AIRCRAFT PAINT SCHEME PER AIRCRAFT MAINTENANCE MANUAL

B	ADD -021/-025 KITS, SHEETS 6 & 7	DB	13.10.17
A	NEW ISSUE	DB	09.01.14
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	DB		
CHECKED	A.P.		
MFG. APPR.	N/A		
APPROVED			
DE APPR.			
DATE	13.10.17		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D412-786-1	REV. B SHEET 1 OF 7
TITLE HARDPOINT KIT INSTALL	SCALE NTS
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